Date User:

Monday, 2/19/2007 8:07:53 AM

Kim Johnston

### **Process Sheet**

Customer Job Number : CU-DAR001 Dart Helicopters Services

**Estimate Number** 

: 12720

P.O. Number

This Issue Prsht Rev.

First Issue

:NIA

: 2/19/2007

S.O. No. : NIA

: SMALL /MED FAB

Previous Run

Written By Checked & Approved By

Comment

**Part Number Drawing Number** 

**Drawing Name** 

: D353623

: GASKET

D3536 UNDER REVIEW

: N/A Project Number : U/R **Drawing Revision** 

Material

: NIA

: 2/26/2007 **Due Date** 

12 Um:

Each

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

1.0

MNEO60S063

NEOPRENE SHEET 0.063



Comment: Qty.:

1.4033 sf(s)/Unit Total:

16.8399 sf(s)

**NEOPRENE SHEET 0.063** 

Batch: M103164

2.0

WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D3536 Dwg Rev:\_\_

SAD 07/03/10 2-Deburr if necessary

3.0

INSPECT PARTS AS THEY COME OFF MACHINE

SAO



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:\_

Boxf13 (12) (1)

QTO

### **Dart Aerospace Ltd**

| W/O: |             | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|-------------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP        | PROCEDURE CHANGE   | Ву | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |             |                    |    |      |     |                                     |                          |  |
|      |             | ,                  |    |      |     |                                     |                          |  |
|      | in          |                    |    |      |     |                                     |                          |  |
|      |             |                    |    |      |     |                                     |                          |  |
|      | <del></del> |                    |    | L    |     | !                                   | L                        |  |

Part No: \_\_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_ Date: \_\_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR:               |      | W  | ORK ORI              | DER NON-CONFORMANC  | E (NCR)          |                           |                       |                          |
|--------------------|------|--|----------------------|---|------------------|---------------------------|-----------------------|--------------------------|
| DATE               | STEP | Description of NC<br>Section A                     | Initial<br>Chief Eng | Corrective Action Section B  Action Description Chief Eng | Sign &           | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
| Osloslo<br>Osloslo | 2.0  | water jet didn't cut one correctly Scrap one prese | brose                | Scrap and dectroy replace                                 | offortion<br>SAN | 07/03/12                  | PESSIU42              | A<br>07/03/12            |
|                    |      |  |                      | ,   |                  |                           |                       |                          |
|                    |      | :  |                      |   |                  |                           |                       |                          |
|                    |      | :  |                      |   |                  |                           | 9                     |                          |

NOTE: Date & initial all entries

, Monday, 2/19/2007 8:07:53 AM

User:

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 30754

Part Number: D353623

Job Number:



Seq. #:

Machine Or Operation:

Description:

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

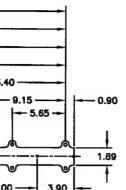


U 67,03:14

| Dart Ae | rospace L  | .td               | 5.                   |                              |                |              |                                     |                        |
|---------|------------|-------------------|----------------------|------------------------------|----------------|--------------|-------------------------------------|------------------------|
| W/O:    |            |                   | W                    | ORK ORDER CHANGE             | S              |              |                                     |                        |
| DATE    | STEP       | į į F             | ROCEDURE CHA         | NGE                          | Ву             | Date Qty     | Approval<br>Chief Eng /<br>Prod Mgr | Approva<br>QC Inspecto |
|         |            | İ                 |                      |                              |                |              | 1                                   | ,                      |
|         |            |                   |                      |                              |                |              |                                     |                        |
|         |            |                   |                      |                              |                |              |                                     | ı                      |
| Part No | ) <b>:</b> | PAR #:            | Fault Cate           | gory:                        | NCR: Yes       | No DQA:      | Date: _                             |                        |
|         |            |                   |                      |                              | QA: N          | /C Closed:   | _ Date: _                           | <del></del>            |
| NCR:    |            |                   | WORK ORD             | ER NON-CONFORMA              | NCE (NCR       | 3)           |                                     |                        |
|         |            | Description of NC | <u> </u>             | Corrective Action Section    |                | Verification | Approval                            | Approva                |
| DATE    | STEP       | Section A         | Initial<br>Chief Eng | Action Description Chief Eng | Sign &<br>Date | Section C    | Chief Eng                           | QC Inspecto            |
|         |            |                   |                      |                              |                |              |                                     |                        |
|         |            |                   |                      |                              |                |              |                                     |                        |
|         |            |                   |                      | ė.                           |                |              |                                     |                        |
| a       |            |                   |                      |                              |                |              | !                                   |                        |
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|         |            |                   |                      |                              | (T)            |              |                                     | :                      |
|         |            |                   | 4                    |                              | 3)             | ÷            |                                     | ۵.                     |

NOTE: Date & initial all entries

26.65 23.15 21.15 17.65 -13.40 - 5.65 DETAIL A 3.90 Ø0.19 (TYP 3 PLS) D3536-11 GASKET



UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE SHOP COPY WORK ORDER RETURN TO ENGINEERING

1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER 7) SEE PAGE 6 FOR DETAILS AND SECTION

32.90 29.40 27.40 23.90 18.98 14.07 0.90 - 5.65 1.89 DETAIL A 3.90 14.00 -#0.19 (TYP 4 PLS) 20.00

D3536-13 GASKET

| OR 10 OF NEW ICCIE      | 06 10 35   | ٨        |  |
|-------------------------|------------|----------|--|
| GASKET 1:10             |            | 06.10.25 |  |
| TITLE SCALE             |            | TIAD     |  |
| D3536 SHEET 1 OF 6      | #          | m        |  |
| DRAWING NO. REV. A      | APPROVED / |          |  |
| PORT HADLOCK, WA        | CB         | CB       |  |
| DART AFROSDACE LISA INC | DRAWN BY   | DESIGN   |  |

.02.12

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35.65 33.65 - 30.15 24.90 -19.65 14.40 -0.90 - 5.65 1.89 3.90 **#0.19** DETAIL A (TYP 4 PLS) 16.00 24.00 D3536-15 GASKET UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE ENGINEERING SHOP COPY RETURN TO

1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
7) SEE PAGE 6 FOR DETAILS AND SECTION

| ŀ        | 32.70              |
|----------|--------------------|
|          | 27.25              |
| DETAIL A | 21.80<br>16.35<br> |
|          | 6.00 8.00          |

| 1:10                     | GASKET      |          | 06.10.25   |
|--------------------------|-------------|----------|--|
| SCALE                    | TITLE       |          | DATE   |
| SHEET 2 OF 6             | D3536       | 4        | THE STATE OF THE S |
| REV. A                   | DRAWING NO. | APPROVED | CHECKED  |
| PORT HADLOCK, WA         |             | 4)       | (6   |
| DART AEROSPACE USA, INC. | DART        | DRAWN BY | DESIGN   |
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PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. - 33.92 28.53 -23.14 -9.50 -DETAIL A 4.75 -2.00 1.89 6.00 0.90 - 16.00 **#0.19** (TYP 6 PLS) - 24.00 32.00 39.00 48.00 D3536-23 GASKET UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE ENGINEERING SHOP COPY RETURN TO - 21.80 16.35 1.45 -DETAIL A 10.90 R0.06 (TYP) 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063) 2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT 
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 1.89 R0.25 (TYP) -- 6.00 5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER **¢**0.19 (TYP 3 PLS) 7) SEE PAGE 6 FOR DETAILS AND SECTION D3536-25 GASKET



| CB       | CB         | PORT HADLOCK, WA   |
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| CHECKED  | APPROVED . | DRAWING NO. REV. A |
| #        | 華          | D3536 SHEET 3 OF   |
| DATE     |            | TITLE SCALE        |
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06.10 DATE

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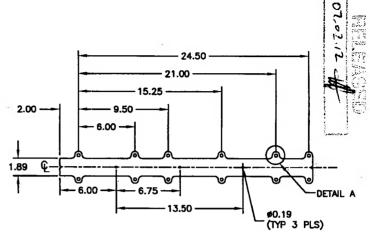
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22.50 19.00 2.00 -9.50 6.00 1.89 Q-DETAIL A ≠0.19 (TYP 3 PLS)

D3536-31 GASKET



D3536-33 GASKET

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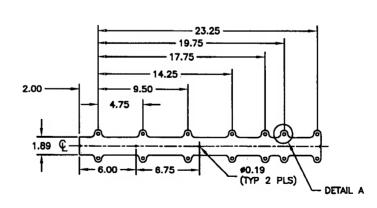
1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

2) FINISH: NONE

PART IS SYMMETRICAL ABOUT &
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

7) SEE PAGE 6 FOR DETAILS AND SECTION



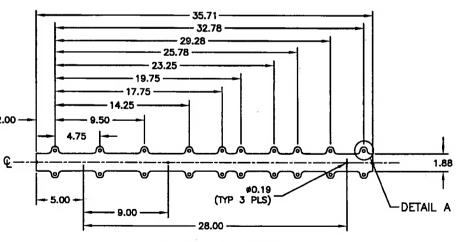
D3536-35 GASKET

|        |         | THE PROPERTY OF THE PROPERTY O | MAPPROVED A | BCB                      |
|--------|---------|--|-------------|--------------------------|
| GASKET | TIMLE . | D3536  | DRAWING NO. | DAK! AE                  |
|        |         | SHE  |             | DAKI AEKOSPACE USA, INC. |
| 1:10   | SCALE   | SHEET 4 OF 6   | REV. A      | INC.                     |

07.02.12

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30.75 27.25 22.50 2.00 4.75 1.89 Œ - 6.00 21.00 D3536-37 GASKET UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE SHOP COPY RETURN TO ENGINEERING 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEOBO-S.063) 2) FINISH: NONE
3) PART IS SYMMETRICAL ABOUT 
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 2.00 -5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER 7) SEE PAGE 6 FOR DETAILS AND SECTION



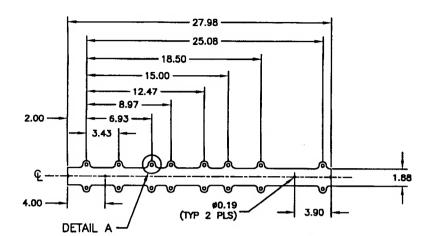
**D3536-39 GASKET** 

DETAIL A

#0.19 (TYP 4 PLS)

| CB          | CB       | DAK         | PORT HADLOCK, WA | DOA, INC.    |
|-------------|----------|-------------|------------------|--------------|
| <br>CHECKED | APPROVED | DRAWING NO. |                  | REV. A       |
| <b>₹</b>    | #        | D3536       |                  | SHEET 5 OF 6 |
| <br>DATE    |          | TULL        |                  | SCALE        |
| 06.10.25    |          | GASKET      |                  | 1:10         |

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# D3536-41 GASKET

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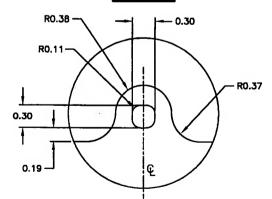
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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 3) PART IS SYMMETRICAL ABOUT ©
  4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
  6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

## **DETAIL A**



| 1:10                     | GASKET      |             | 06.10.25 |
|--------------------------|-------------|-------------|----------|
| SCALE                    | TIME .      |             | DATE     |
| SHEET 6 OF 6             | D3536       | #           | m        |
| REV. A                   | DRAWING NO. | APPROVED // | CHECKED  |
| PORT HADLOCK, WA         |             | CB          | CB       |
| DART AEROSPACE USA. INC. | DARI        | DRAWN BY    | DESIGN   |

| DART AEROSPACE LTD     | Work Order: 30754     |
|------------------------|-----------------------|
| , b +                  | Part Number: 73536-23 |
| Description: basket    |                       |
| Inspection Dwg: A Rev: | . Page 1 of 1         |

# FIRST ARTICLE INSPECTION CHECKLIST

| x First Article | x Prototype |  |
|-----------------|-------------|--|
|-----------------|-------------|--|

| Drawing<br>Dimension | Tolerance | Actual<br>Dimension | Accept | .ejest   | Method of Inspection | Comments   |
|----------------------|-----------|---------------------|--------|--|----------------------|--|
| 52, 85               | 4-0.030   | 52.875              | /      |  | M-T/very             | The second secon |
| 48. 20               | +1-0.030  | 47.250              |        |  | M+T                  |  |
| 44.70                | 1/-0.030  | 44.68               |        |  | H-1 /vern            |  |
| 39.31                | 1/-0.030  | 39,50               | ~      | with the analysis and the second specific to the second se | M-1 per              |  |
| 33,42                | 1/-0.030  | 33, 95              |        |  | M-T luenn            | and the state of t |
| 78.53                | t-0.030   | 28.56               | /      |  | H-1/vern             |  |
| 23.14                | 1-000000  | 23,170              |        |  | H-T/vern             | عاممه العاد والسيوان والسورانيين   |
| 17, 75               | 1/-0.030  | 17.75               |        |  | M-T                  | man and a special of a section of the section of th |
| 14, 25               | 1/- 0.030 | 14.25               | /      | 1  | M-T                  | and the same of th |
| 9.50                 | +1-0.030  | 9.50                | /      |  | M-T                  |  |
| 4.75                 | 1-0.030   | 4.75                | ~      |  | M-T                  | p  |
| 8.00                 | +60.030   | 8.03                | /      |  | Varn                 |  |
| 16.00                | th. 0.030 | 16.02               | V      |  | Vern                 |  |
| 24.00                | 1/-0.030  | 24.02               |        |  | Vern                 |  |
| 32.00                | 4.0.030   | 32.01               | /      |  | Very                 | particular, the property and the Appendix  |
| 3900                 | 4.0.030   | 39.01               | /      |  | Very                 |  |
| 48.00                | 1/2 0.030 | 98,00               | _      |  | Very                 |  |
| Ø0.19                | 1/-0.030  | Ø 0.193             |        |  | Vern                 |  |
| ED. 0.30             | 7.0.030   | 0.317               | · ·    |  | Very                 | and the second s |
| 0.30                 | -60.070   | 0.317               |        |  | Ven                  |  |
| 1.89                 | 4.0.030   | 1.91                | 1      | \$\$   | Very                 |  |
|                      |           |                     |        |  |                      | ALLEGE TO SELECT AND ADDRESS OF THE  |

| Measured by: SAN | Audited by: | Prototype Approval: |
|------------------|-------------|---------------------|
| Date: 07/03/10"  | Date:       | Date:               |
| 19 7709 10       |             | Revised by Approve  |

| Rev | Date | Change    |        | Approve |
|-----|------|-----------|--------|---------|
| Д   |      | New Issue | KJ/JLM | <u></u> |

